

SOLD

SHIP 3-22



Dart Aerospace Ltd.  
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**D350-636-011**  
**Job Sheet 172901**

**Part No:** D350-636-011**Job Qty:** 1 pcs**Part Name:** Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 2/22/18**Job Tracking No:****Due Date:** 3/22/18**Created By:** Logan David**Type:** SOLD**Description:**

**Note:** D2750-041 REV G SHEETS 1,2,4,8 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13  
As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Ver:EC IPP Rev:M 08-04-22 DD  
verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD ver:EC IPP  
Rev:P 10.06.22 revise seq110 DD ver:EC IPP Rev:Q 10.10.01 as per IIN revH DDver:EC IPP REV:R  
13.08.27 PER ECN13-594 DD VERF:JLM

**Ship Via:****Bill of Materials**

S048946LH



Container No: S048946



Part: D350-636-011

Job No: 172901

Serial No/Batch: S048946

Revision:

Inspector:

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Date: 03/08/18



| Job Routing |                    |       |            |          |           |         |                       |           |             |
|-------------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
| Op No       | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|             |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90          | Start up Operation | 1 Ea  | 3/21/18    |          | 0.00      | 0.00    | Start Up Skid tubes-1 |           | SA          |
| 110         | Skid tubes         | 1 pcs | 3/21/18    |          | 0.00      | 4.55    | Skid tubes-4          |           | SA          |
| 120         | QC                 | 1 pcs | 3/21/18    |          | 0.00      | 0.00    | QC10                  |           | 38 DAS      |
| 130         | QC                 | 1 pcs | 3/21/18    |          | 0.00      | 0.00    | QC5                   |           | 9-88 38     |
| 140         | HandFinish         | 1 pcs | 3/21/18    |          | 0.00      | 0.93    | HandFinish1           |           | SA 18-03-20 |
| 150         | QC                 | 1 pcs | 3/21/18    |          | 0.00      | 0.00    | QC7-2                 |           |             |
| 160         | Skid tubes         | 1 pcs | 3/21/18    |          | 0.00      | 4.55    | Skid tubes-4          |           | SA          |
| 170         | QC                 | 1 pcs | 3/21/18    |          | 0.00      | 0.00    | QC10                  |           | 38 DAS      |
| 180         | QC                 | 1 pcs | 3/21/18    |          | 0.00      | 0.00    | QC5                   |           | 9-88 38     |
| 190         | HandFinish         | 1 pcs | 3/21/18    |          | 0.00      | 0.93    | HandFinish2           |           | SA 18-3-20  |
| 200         | Spray Paint        | 1 pcs | 3/21/18    |          | 0.00      | 0.91    | Spray Paint           | PO 039358 | CT 18-3-20  |
| 210         | QC                 | 1 pcs | 3/21/18    |          | 0.00      | 0.00    | QC14                  |           | M 18-3-26   |
| 230         | HandFinish         | 1 pcs | 3/22/18    |          | 0.00      | 0.93    | HandFinish4           |           | 18-3-26     |
| 240         | QC                 | 1 pcs | 3/22/18    |          | 0.00      | 0.00    | QC5                   |           | 38          |
| 250         | Packaging          | 1 pcs | 3/22/18    |          | 0.00      | 0.00    | Packaging1-3          |           | 9-88        |
| 260         | QC                 | 1 pcs | 3/22/18    |          | 0.00      | 0.00    | QC4                   |           | 38          |
| 265         | DC                 | 1 pcs | 3/22/18    |          | 0.00      | 0.00    | DC                    |           | 38          |
| 270         | Packaging          | 1 pcs | 3/22/18    |          | 0.00      | 0.00    | Packaging3-1          |           | 38          |
| 280         | QC21-FG            | 1 Ea  | 3/22/18    |          | 0.00      | 0.00    | QC21                  |           | 38          |
| 330         | Packaging          | 1 pcs | 3/22/18    |          | 0.00      | 0.00    |                       |           | 38          |

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg  
 Descriptions: D2750-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. \*\*\*ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE\*\*\* Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6- Open up holes of Detail A to 0.297" (total of 2 holes per side) 7- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: M138663 8- Grind welds flush as per Dwg D2750  
 160 - 1- Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2- Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float hole using un-bit to 0.500" (4 per side) 4- Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: exp. date: \*\*\*ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)\*\*\* 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 038611 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10- Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.  
 180 - \*\*\*VERIFY C'BOARD IS GOOD\*\*\*  
 190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.  
 200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: \_\_\_\_\_ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: \_\_\_\_\_  
 210 - Inspect for foreign object per QSI 024  
 230 - 1- Install inserts as per Dwg D2750 2- Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: M138787 EXP DATE: 18/12/18 4- Assemble o-ring to plug as per dwg D3492 and apply o-ring lube A/R 55-o-ring lube batch: M135477 5- Coat all exposed fasteners with "LPS Procyon" batch: M133690  
 260 - \*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*  
 265 - record fwd angle: 89.70 Photocopy blue file and type labels per PPP D350-636-011 CHG 007  
 270 - Package as per PPP D350-636-011 Location : FG072



| Job BOM         |                   |               |                       |                          |
|-----------------|-------------------|---------------|-----------------------|--------------------------|
| Part / Item     | Component Name    | Quantity      | Operation             | Container                |
| D2600-3-BENT-LH | Extrusion Bent LH | 1 Ea (1 ea)   | 90-Start up Operation | 6043969                  |
| D2744           | Cap               | 1 Ea (1 ea)   | 90-Start up Operation | 5038835                  |
| D2739           | 350 I-Beam        | 1 Ea (1 ea)   | 160-Skidtubes         | 5040985                  |
| D2743           | Crossbolt Spacer  | 8 Ea (8 ea)   | 160-Skidtubes         | 5026588 x 2 3000 649 x 6 |
| D3490-1         | Cross Bolt Spacer | 4 Ea (4 ea)   | 160-Skidtubes         | 5039269                  |
| D3490-3         | Cross Bolt Spacer | 4 Ea (4 ea)   | 160-Skidtubes         | 5040318                  |
| AN3C5A          | Bolt              | 34 Ea (34 ea) | 230-HandFinish        | 5019396                  |
| AN3C6A          | Bolt              | 4 Ea (4 ea)   | 230-HandFinish        | 5019397                  |
| AN6C44A         | Bolt              | 4 Ea (4 ea)   | 230-HandFinish        | F111837055               |
| AN8C35A         | Bolt              | 1 Ea (1 ea)   | 230-HandFinish        | F1137207                 |
| D2745           | Bushing           | 8 Ea (8 ea)   | 230-HandFinish        | 5026936                  |
| D3488-041       | Blade Fitting LH  | 1 Ea (1 ea)   | 230-HandFinish        | 5040142                  |
| D3492-1         | Plug              | 8 Ea (8 ea)   | 230-HandFinish        | 5044321                  |
| D3492-3         | Plug              | 8 Ea (8 ea)   | 230-HandFinish        | 5026057                  |
| D3535-25        | Wearplate Center  | 1 Ea (1 ea)   | 230-HandFinish        | 5047127                  |
| D3536-25        | Gasket Center     | 1 Ea (1 ea)   | 230-HandFinish        | 5047787                  |
| D3537-1         | Wearpad           | 3 Ea (3 ea)   | 230-HandFinish        | 5037408                  |
| D3631-1         | Washer            | 8 Ea (8 ea)   | 230-HandFinish        | 5048060                  |
| D3791-1         | Wearpad           | 1 Ea (1 ea)   | 230-HandFinish        | 5024340                  |
| D3793-1         | Wearplate Fwd     | 1 Ea (1 ea)   | 230-HandFinish        | 5038363                  |
| D3793-3         | Wearplate Aft     | 1 Ea (1 ea)   | 230-HandFinish        | 5041206                  |
| D3794-1         | Gasket Fwd        | 1 Ea (1 ea)   | 230-HandFinish        | 5046363                  |
| D3794-3         | Gasket Aft        | 1 Ea (1 ea)   | 230-HandFinish        | 5046244                  |
| MS21043-6       | Nut               | 4 Ea (4 ea)   | 230-HandFinish        | 5041601                  |
| MS21083C8       | Nut               | 1 Ea (1 ea)   | 230-HandFinish        | 5034401                  |
| NAS1149C0332R   | Washer            | 38 Ea (38 ea) | 230-HandFinish        | 5044236                  |
| NAS1149C0832R   | Washer            | 1 Ea (1 ea)   | 230-HandFinish        | M139,409-121             |
| NAS1515H3L      | Washer            | 4 Ea (4 ea)   | 230-HandFinish        | F11137361-25             |
| NAS1611-010     | O-Ring            | 8 Ea (8 ea)   | 230-HandFinish        | 5049970                  |
| NAS1611-013     | O-Ring            | 8 Ea (8 ea)   | 230-HandFinish        | M1138441-122             |
| ALS4-1032-225   | Rivnut            | 38 Ea (38 ea) | 230-HandFinish        | 5048375                  |
| AN8C21A         | Bolt              | 2 Ea (2 ea)   | 250-Packaging         | F1137162                 |
| D2741           | Replacement Blade | 1 Ea (1 ea)   | 250-Packaging         | F1163260-1               |
| D3493-1         | Washer            | 2 Ea (2 ea)   | 250-Packaging         | 5031096                  |
| D3532-1         | Spacer            | 2 Ea (2 ea)   | 250-Packaging         | 5040493                  |
| MS21083C8       | Nut               | 2 Ea (2 ea)   | 250-Packaging         | 5016888                  |
| NAS1149D0863J   | Washer            | 2 Ea (2 ea)   | 250-Packaging         | F125635                  |

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### Job Allocations

| Operation             | Component Part  | Required | Inventory | Allocated |
|-----------------------|-----------------|----------|-----------|-----------|
| 90-Start up Operation | D2600-3-BENT-LH | 1        | 16        | 0         |
|                       | D2744           | 1        | 28        | 0         |
|                       | D2739           | 1        | 27        | 0         |
| 160-Skidtubes         | D2743           | 8        | 151       | 0         |
|                       | D3490-1         | 4        | 128       | 0         |
|                       | D3490-3         | 4        | 107       | 0         |
|                       | ALS4-1032-225   | 38       | 1,075     | 0         |
|                       | AN3C5A          | 34       | 805       | 0         |
| 230-HandFinish        | AN3C6A          | 4        | 170       | 0         |
|                       | AN6C44A         | 4        | 447       | 0         |
|                       | AN8C35A         | 1        | 73        | 0         |
|                       | D2745           | 8        | 105       | 0         |
|                       | D3488-041       | 1        | 14        | 0         |
|                       | D3492-1         | 8        | 199       | 0         |
|                       | D3492-3         | 8        | 152       | 0         |
|                       | D3535-25        | 1        | 25        | 0         |
|                       | D3536-25        | 1        | 16        | 0         |
|                       | D3537-1         | 3        | 103       | 0         |
|                       | D3631-1         | 8        | 54        | 0         |
|                       | D3791-1         | 1        | 11        | 0         |
|                       | D3793-1         | 1        | 27        | 0         |
|                       | D3793-3         | 1        | 30        | 0         |
|                       | D3794-1         | 1        | 20        | 0         |
|                       | D3794-3         | 1        | 10        | 0         |
|                       | MS21043-6       | 4        | 119       | 0         |
|                       | MS21083C8       | 1        | 91        | 0         |
|                       | NAS1149C0332R   | 38       | 4,708     | 0         |
|                       | NAS1149C0832R   | 1        | 98        | 0         |
|                       | NAS1515H3L      | 4        | 295       | 0         |
|                       | NAS1611-010     | 8        | 279       | 0         |
|                       | NAS1611-013     | 8        | 367       | 0         |
| 250-Packaging         | AN8C21A         | 2        | 166       | 0         |
|                       | D2741           | 1        | 82        | 0         |
|                       | D3493-1         | 2        | 40        | 0         |
|                       | D3532-1         | 2        | 56        | 0         |
|                       | MS21083C8       | 2        | 91        | 0         |
|                       | NAS1149D0863J   | 2        | 167       | 0         |

### Part Specifications

Specifications could not be found.

Plex 2/22/18 2:10 PM dart.logan.david